

Work Order ID 71589

Wednesday, July 06, 2011 1:26:16 PM



Page 1

Item ID: D3720-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CX Date: 11/07/06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3720 | Rev A | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-

Deburr if necessary

6661 - 126

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11/07/28 (12)

11/07/28 (12)

11 07 28 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 71589

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Item ID: D3720-2

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Setup Start



Revision ID:

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Item Name: Step Spacer

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 12 | 12 | 11-7-29 | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: <u>SXVIR</u> Memo | 0.00 0.00 | | | | | | | <u>11/8/12</u> (12) |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>ck 11/08/02</u> <u>11-08-2</u> (12) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:26:14 PM

Page 1

Work Order ID: 71589

Parent Item: D3720-2

Parent Item Name: Step Spacer



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.125 | | Purchased | No | | | 110 | sf | 84.5514 | 0.085 | 1.073684 | | | |
| | | | | | | | | | | | | | |
| 6061-T6 .125 Sheet | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

MAT021

84.55136842

113608

77.17

116700

7.38136842

1.2 ~~11~~ 11/07/28

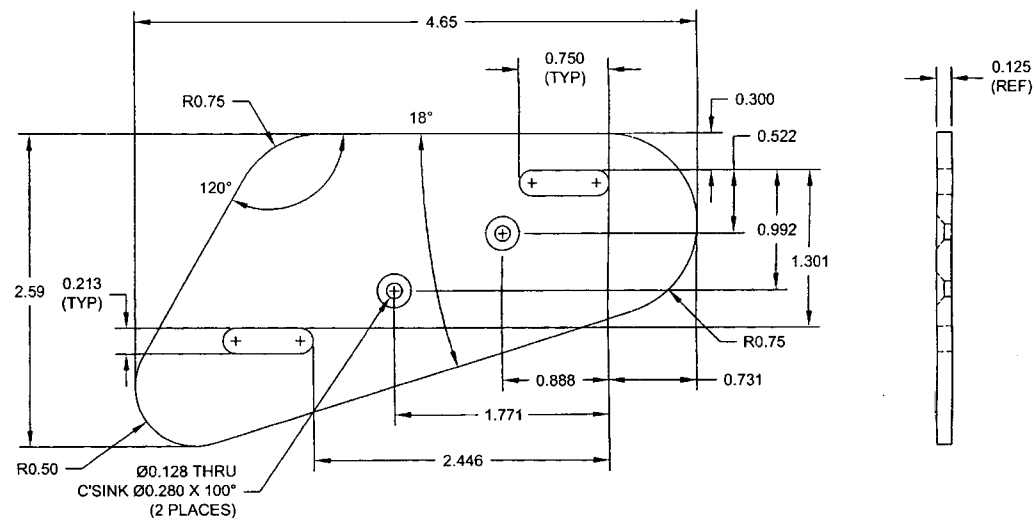
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

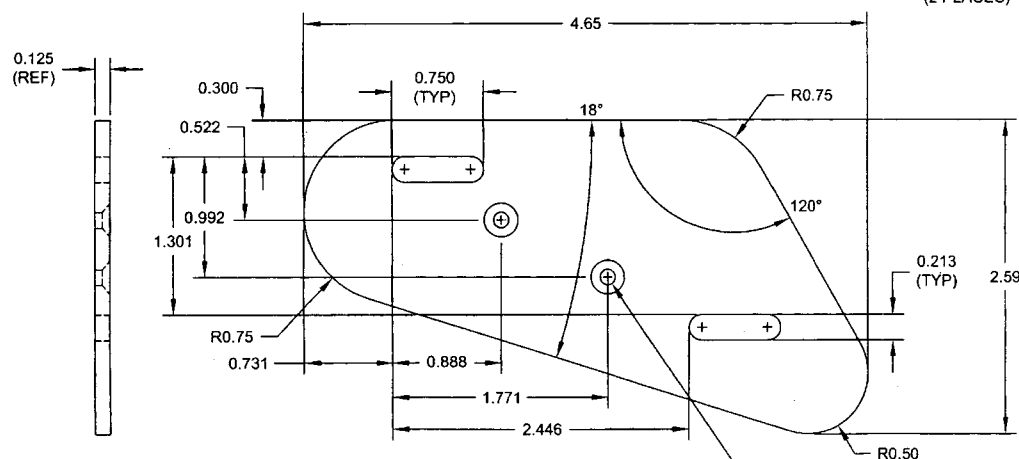
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71587

CL1107106

RELEASED
86-10-10

| | | | | |
|------------|-----------|--|--|--------------|
| A | NEW ISSUE | | PH | 07.12.27 |
| REV. | | DESCRIPTION | BY | DATE |
| DESIGN | AK | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | BE | | | |
| CHECKED | LS | | DRAWING NO. | REV. A |
| MFG. APPR. | DA | | D3720 | SHEET 1 OF 1 |
| APPROVED | TH | | TITLE | SCALE |
| DE APPR. | TH | | STEP SPACER | 1 |
| DATE | 07.12.27 | | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

